

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009664**Date Inspected:** 11-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Chen ying xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay -10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053049 perform SMAW welding on, Spare strut flange to web, Weld joint no. ED1-A6001-3-10A. ZPMC CWI Identified as Mr. Chen ying xin . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-TC-U5B-1

Machining area

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066479 perform SMAW surface repair welding on, Skin C, East tower, lift 3. ZPMC CWI Identified as Mr. An qing xiang . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) - repair.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040723 perform FCAW surface repair welding on, Fit lug of Skin A, inside East tower, lift 3, on 89 mtr. Diaphragm. ZPMC CWI Identified as Mr. An qing xiang . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F) - repair.

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## WELDING INSPECTION REPORT

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### Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as South tower, Lift 3, Skin A, Manhole and manhole step plate, Skin B N&C stiffeners. The weld designations reviewed are as follows:

SSD1-FASA3-1C/E- Jt. no. 7, 18, 19, 20–south, Lift 3 – Skin A manhole plate

SSD1-FASA3-1C/E- Jt. no. 5, 6–south, Lift 3 – Skin A manhole step plate

SSD1-FBSA3-1B/C- Jt. no. 13 to 16–south, Lift 3 – Skin B stiffener gusset plate

SSD1-FBSA3-1C/C- Jt. no. 9, 11–south, Lift 3 – Skin C stiffener gusset plate

### Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as East tower, Lift 3, BC corner Diagonal plate Butt joints, Machining area. The weld designation reviewed is as follows:

ESTL3-4 K/K- Jt. no. 1 to 12, 27 to 34, 18, 45, 46, 52

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar, Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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